

304 1.50

Work Order ID 73619

Wednesday, September 07, 2011 2:36:21 PM



Page 1

Item ID: D3443-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Clevis

Start Date: 9/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/22/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3443

Rev C

100

0.00



Doosan

Memo

0.00

Doosan Lathe

1-TURN AS PER FOLIO FA588 & DWG D3443

FOLIO REV: 5/1A

DWG REV: 2

2-DEBURR AS REQUIRED

11/10/04

10 φ

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/20/04

10 φ

160

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Y.A 11/10/05

10 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73619

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Page 2

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

170

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

*****STOCK IN LARGE FAB*****

(10x) SP 11-10-6.

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/11
CNF 11-10-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 07, 2011 2:36:18 PM

Page 1

Work Order ID: 73619

Parent Item: D3443-3

Parent Item Name: Clevis



Start Date: 9/7/2011

Required Date: 9/22/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: A 05.11.14 New issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit Qty	Total Qty	Qty Issued	Date Issued	Status
M304R1.500		Purchased	No			100	f	9.3520	0.25	2.5			
304 round bar 1.500													

Location

Loc Qty

Loc Code

MAT029

9.352

106260

0.272

106260

9.08

303

10/10/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order:	73619
Description: Clevis		Part Number:	D3443-3
Inspection Dwg: D3443	Rev: C	Page 1 of 1	

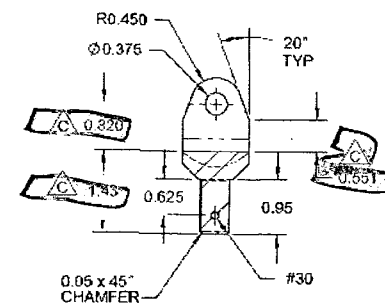
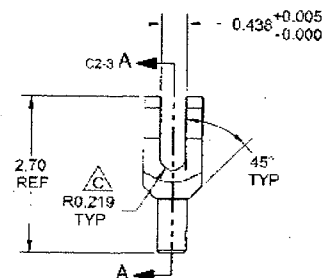
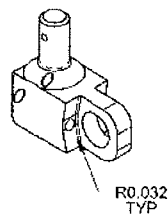
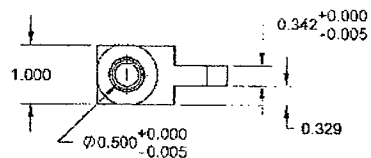
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

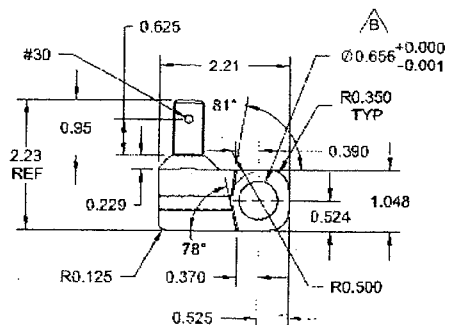
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.70	+/-0.030	2.706	/		SA-9	
0.95	+/-0.030	.952	/			
Ø0.500	+0.000/-0.005	Ø.498	/			
20°	+/-0.5°	20°	/			
R0.450	+/-0.010	R.450	/			
Ø0.375	+0.006/-0.001	Ø.377	/			
0.451	+/-0.010					
0.625	+/-0.010	.625	/			
1.43	+/-0.030	1.435	/			
0.720	+/-0.010					
0.05 x 45°	+/-0.5°	0.050 x 45°	/			
45°	+/-0.5°	45°	/			
1.00	+/-0.030	1.00	/			
1.125	+/-0.010	1.125	/			
0.438	+0.005/-0.000	.439	/			
R0.219	+/-0.010	R.219	/			
.551	± .010	.550	/			Rev. C
.820	± .010	.820	/			Rev. C

Measured by: SA	Audited by: SA	Prototype Approval:	N/A
Date: 11/10/04	Date: 11/10/05	Date:	N/A

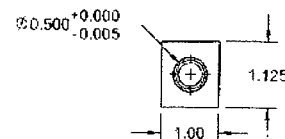
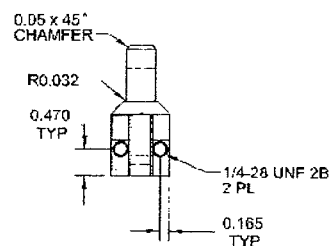
Rev	Date	Change	Revised by	Approved
A	06.06.28	New Issue	KJ/JLM	
B	09.11.04	Dimensions updated per Dwg Rev C	KJ	M



SECTION A-A C4-3



D3443-1 LUG



~~D3443-3 CLEVIS~~

RELEASED
01/26/25/14

NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY NTS	
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD	